

Date: Thursday, 12/10/2006 11:46:04 AM
 User: Linda Lacelle

Process Sheet

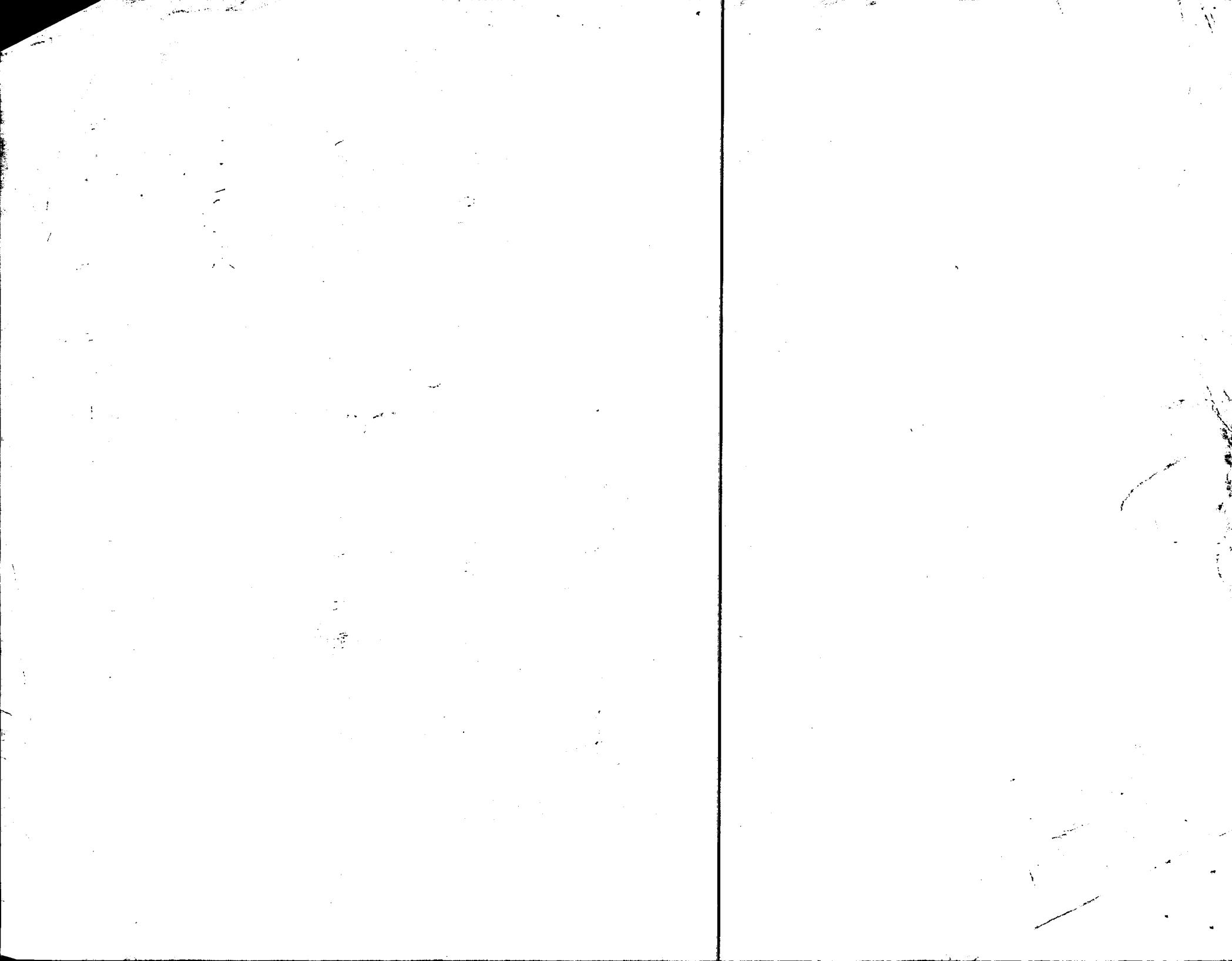
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: NUT PLATE		
Job Number	: 28935		Part Number	: D2680041		
Estimate Number	: 10316		Drawing Number	: D2680 REV B1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/10/2006	S.O. No. : N/A	Drawing Revision	: B1		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 30/10/2006 Qty: 50 Um: Each		
Previous Run	: 28935					
Written By	:					
Checked & Approved By	:					
Comment	: Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM Est Rev:E Now on WaterJet 06-10-12 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.6878 sf(s) 1010/1025/A21/6aA SHEET .063" thk Batch: M9131 ml 06 12 04 (50)
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2680 Dwg Rev: B1 ml 06 12 04 (50) Prog Rev: B1
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		ml 06 12 04 (50)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		ml 06 12 04 (50)
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		ml 06 12 04 (50)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr 5AD 06/12/09 (50) 2-C'sink as per Dwg D2680 ml 06/12/22 — ml 07/01/08 (50)



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M102301



50x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m. A / m

07/01/11

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(50)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M101011

8.0 MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-3	Rivet	M7681

9.0 MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21069L4	Nut Plate	M5865

ml

ml

x50

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

ml07/01/22

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/22 (50)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3155

07/01/22 (50)
07/01/22 (50) P71/m

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

58

12/10/23

Job Completion



U 890123

Date: Wednesday, 10/11/2006 12:49:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: NUT PLATE		
Job Number	: 28935					
Estimate Number	: 10316					
P.O. Number	:			Part Number	: D2680041	
This Issue	: 10/11/2006		S.O. No.	: D2680 REV B1		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: PURCHASED PARTS		
Previous Run	: 24203			Material	:	
Written By	:			Due Date	: 10/30/2006	
Checked & Approved By	: <i>[Signature]</i> 06.10.11			Qty:	50	Um: Each
Comment	: Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: _____ 1-Email or Ship DXF file to vendor 2-Laser Cut flat pattern as per Dwg D2680 3- Possible Supplier: GFI or Industrial Laser 4-Material release note is required	<i>M103166A 0/B/SF</i>
2.0	D26801F	NUTPLATE FLAT	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Nut Plate	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr 2-C'sink as per Dwg D2680	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	MS20426AD33	Rivet
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-3	Rivet	_____

9.0	MS21069L4	Nutplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21069L4	Nut Plate	_____

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/11/2006 12:49:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 28935

Part Number: D2680041

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

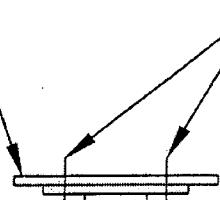
DART

COPY ISSUED
12/14/98

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	BELLEVUE, WA
<i>CP</i>	<i>KE</i>	D2680	REV. B
DATE	TITLE	SCALE	SHEET 1 OF 1
98.12.14	NUT PLATE	1:1	
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	04.11.04	CHANGE HOLES & FINISH	

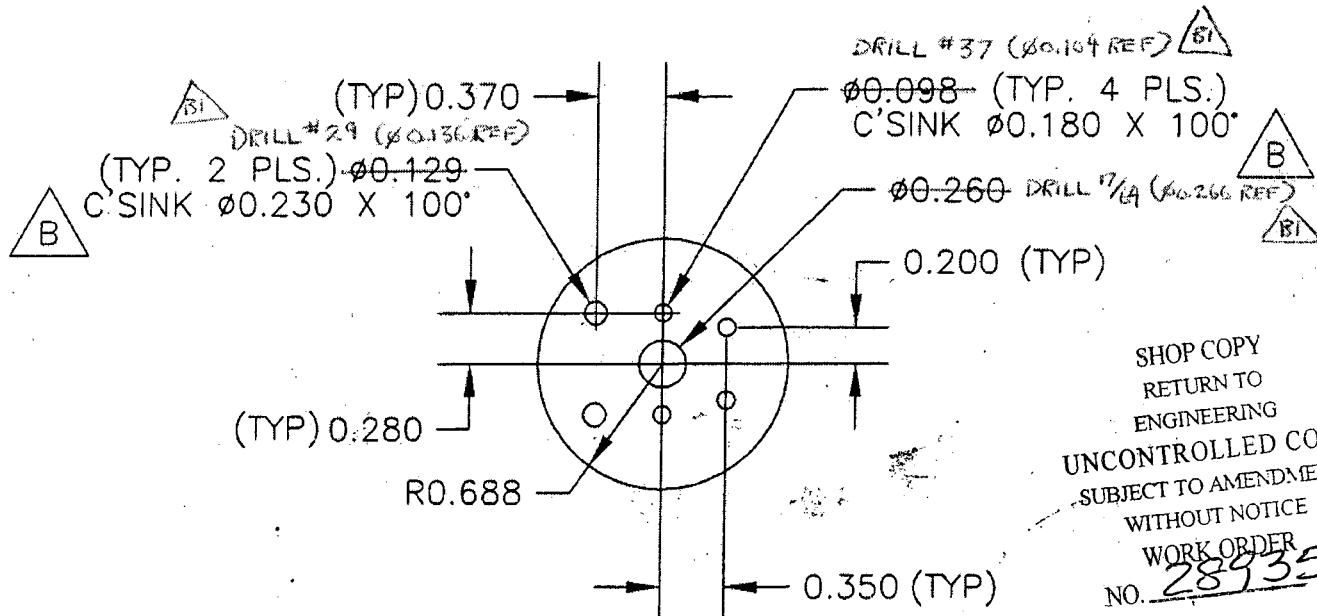
RELEASED
12/14 DS

D2680-1 INSTALL WITH MS20426AD3-3 RIVETS



MS21069L4 NUT PLATE

D2680-041



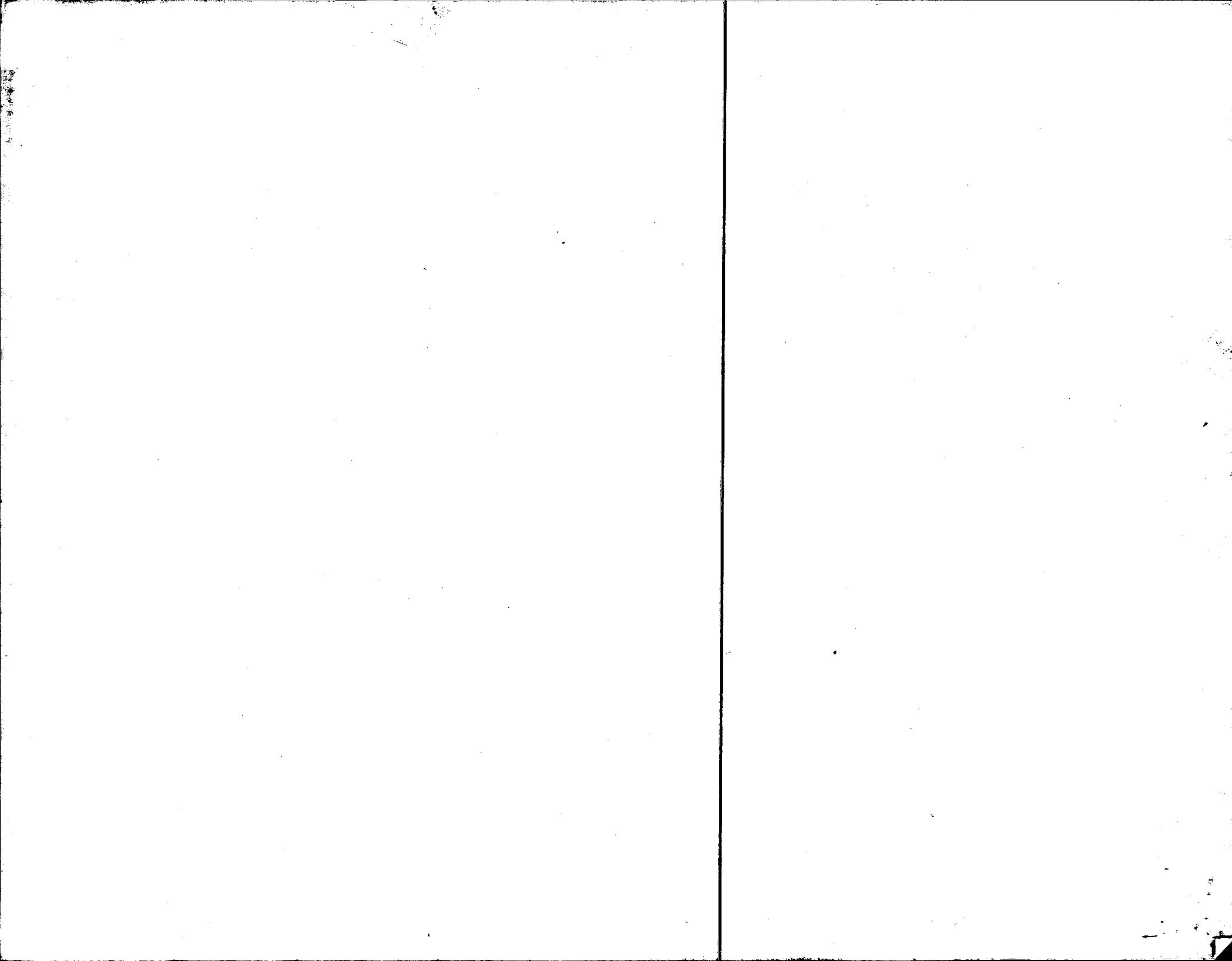
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

△ POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

D2680-1



DART AEROSPACE LTD

Work Order: 08935

Description: Nut plnt

Part Number: D2680-1

Inspection Dwg: D2680 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	MH
Date:	06/12/04

Audited by:	
Date:	06/12/04

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

